



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DSK078

Job Sheet 180909



Part No: DSK078

Job Qty: 4 ea

Part Name: D2893-1 Turning Detail



10ea

DAS

21

9-89

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP rev A. 08.03.13 new issue EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	8/3/18	8/3/18	0.00	0.00	Start Up Machining-4		
100	Doosan	4 pcs	8/3/18	8/3/18	0.50	18.71	Doosan		
110	QC	4 pcs	8/3/18	8/3/18	0.00	0.00	QC2 Machining-4		
120	QC	4 pcs	8/3/18	8/3/18	0.00	0.00	QC8 Machining-4		
130	Packaging	4 pcs	8/3/18	8/3/18	0.00	0.00	Packaging3-2		
140	QC21-SA	4 Ea	8/3/18	8/3/18	0.00	0.00	QC21		

Part Op 100 - Turn blank as per Folio FA081 (4TH AXIS PLUG DT8492)
Descriptions: 130 - LOCATION: MAT060

DAS
21
9-89
AUG 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6104-005	Round Billet, 17-4	4 Ea (1 ea)	90-Start up Operation	5081279

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6104-005	4	12	0

Part Specifications

Specifications could not be found.

Plex 7/17/18 2:54 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 180909
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	2.707	2.70				
B	4.946	4.966		4.955				
C	3.064	3.084		3.074				
D	0.718	0.738		.730				
E	0.090	0.110		.0925				
F	2.934	2.954		2.9435				
G	2.166	2.186		2.1765				
H	3.890	3.910		3.898				
I	0.914	0.934		.928				
J	0.022	0.042		R.032				
K	0.109	0.129		.121				
L								
M								
N								
O								
P								

Measured by: Dave C. [Signature]	Date: 18/09/09
Audited by: [Signature]	Date: 18/09/22
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM [Signature]	[Signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
NCR No. _____	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition

		Completed By
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		Lead hand / Supervisor
		Approval Verification

QC / QA Coordinator

Approval _____

Ltd.
et
4 1K7
200
ro.com
com

Dart Aerospace
 270 Aberdeen Street
 Lakesbury, ON K6L 6K6
 CANADA
 TEL.: 1 613 632-5656
 Email: sales@dartaero.com
 www.dartaerospace.com



Date: 08/09/18

	Power Loss/Surge	Positioned Wrong
	Folio/Program	Outside Dimensions
	Grain	Over/Under tolerance

790	00790	Weld	Part Incorrect
		Wrong Stock Pulled	Part Lost/Missing
		Out of Sequence	Part Moved

☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread

Part: DSKC
 Job No: 18
 Serial No: 18
 Revision:
 Inspector:
 Exp Date:
 Instructions:

H:/FUKIVIS/Quality Assurance\approved QA/NCRWU Rev 1